

5/30

DART AEROSPACE LTD.

Work Order:

23802

Description: Saddle Fitting, Aft (Outboard/Inboard)

Part Number:

D2573/D2574

Drawing: D2573 Rev. D/D2574 Rev. D

Qty:

12

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	RF	05.07.14	12
2	MV	Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: B21819	me	05/07/25	12
3	MV	Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: B21817A Batch No: B23299	me	05/07/25	12
4	MV	Fixturing W/O No. / Fixturing Inspection last completed / by /		/ N/A /	/
5	MV	Program Batch No. 33802 Double check by: RF	BC	05.07.25	12
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	me	05/08/02	12
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	me	05/08/03	12
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	me	05/08/03	12
9	MV	Machine keyway as per dwg D2573 & D2574	me	05/08/03	12
10	MV	Deburr and remove all machining marks	me	05/08/03	12
11	MV	Tumble for 20 minutes to remove sharp edges #04.06.21	me	05/08/03	12
12	QC1	Inspect all dimensions to dimension sheets	me	05/08/03	12
13	QC7	Second inspection	BC	05.08.03	12
14	FP	Acid etch and alodine as per QSI 005 4.1	FF	05.08.04	12
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	MM	05.08.06	12
16	QC3	Inspect Powder Coat	DL	05/08/08	12
17	ST	Identify and Stock.	DL	05/08/08	12
18	AC	Cost / Part 152.93 116.00	Suc	05.08.09	12
19	DC	Close W/O 153.20 117.64 Inspection Level 21	RF	05/08/09	12

Rev	Date	Change	Revised By	Approved
D	99.09.09	Added inspection level, Qty column	EC	
E	00.07.04	Removed P/O for powder coat, drawing change rev. C	EC	
F	00.07.20	Removed inspection level 7	EC	
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2574	KJ RF	

RELEASED
02/10/15 RF